

Work Order ID 50090

Page 1

July 08, 2009 9:28:25 AM

Item ID: D2362-3 Accept Setup Start

Revision ID: E1 Stop

Item Name: Support Bracket

Start Date: 7/10/2009 Start Qty: 6.00 Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 6.00 Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
HAAS 1	Memo A A	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA800 Rev: <u>A</u> & Dwg D2362 Rev: <u>E</u> <input type="checkbox"/> 2-Deburr <i>J.L</i> <i>09/07/11</i>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo <i>J.L</i> Quality Control <i>09/07/11</i>	0.00							
120	QC8- Inspect parts - second check	0.00							
QC	Memo <i>S.F</i> Quality Control <i>09/07/11</i>	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50090

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July 08, 2009 9:28:25 AM

Item ID: D2362-3

Accept

Setup Start

Revision ID: E1

Stop

Item Name: Support Bracket

Start Date: 7/10/2009 **Start Qty:** 6.00

Cust Item ID:

Required Date: 7/31/2009 **Req'd Qty:** 6.00

Customer:

Reference:

Approvals:

Process Plan: _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 50090

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July 08, 2009 9:28:25 AM

Reference: _____ **Run** _____ **Start** _____
Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

July 08, 2009 9:28:25 AM

Work Order ID: 50090

Parent Item: D2362-3RevE1

Parent Item Name: Support Bracket

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2397-3RevC		Manufactured	No			100	Each	18.0000	6.0000			

Rubber Cushion

				<u>Warehouse</u>		<u>Loc Qty</u>	<u>Loc Code</u>	<u> </u>	<u> </u>	<u> </u>	<u> </u>	
				<u>Location</u>	Main Warehouse							
				ST		18						
				38054		18						
D2265RevA		Manufactured	No			160	Each	142.0000	6.0000			

Step Bracket

				<u>Warehouse</u>		<u>Loc Qty</u>	<u>Loc Code</u>	<u> </u>	<u> </u>	<u> </u>	<u> </u>	
				<u>Location</u>	Main Warehouse							
				ST		142						
				37477		42						
				44114		100						
D2397-1RevC		Manufactured	No			160	Each	19.0000	6.0000			

Rubber Cushion

				<u>Warehouse</u>		<u>Loc Qty</u>	<u>Loc Code</u>	<u> </u>	<u> </u>	<u> </u>	<u> </u>	
				<u>Location</u>	Main Warehouse							
				ST		19						
				38053		19						

EBos/07/13

DTP096769

EP09/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	50090
Description: Support bracket	Part Number:	2362-3
Inspection Dwg: A2362-3	Rev: E	Page 1 of 1

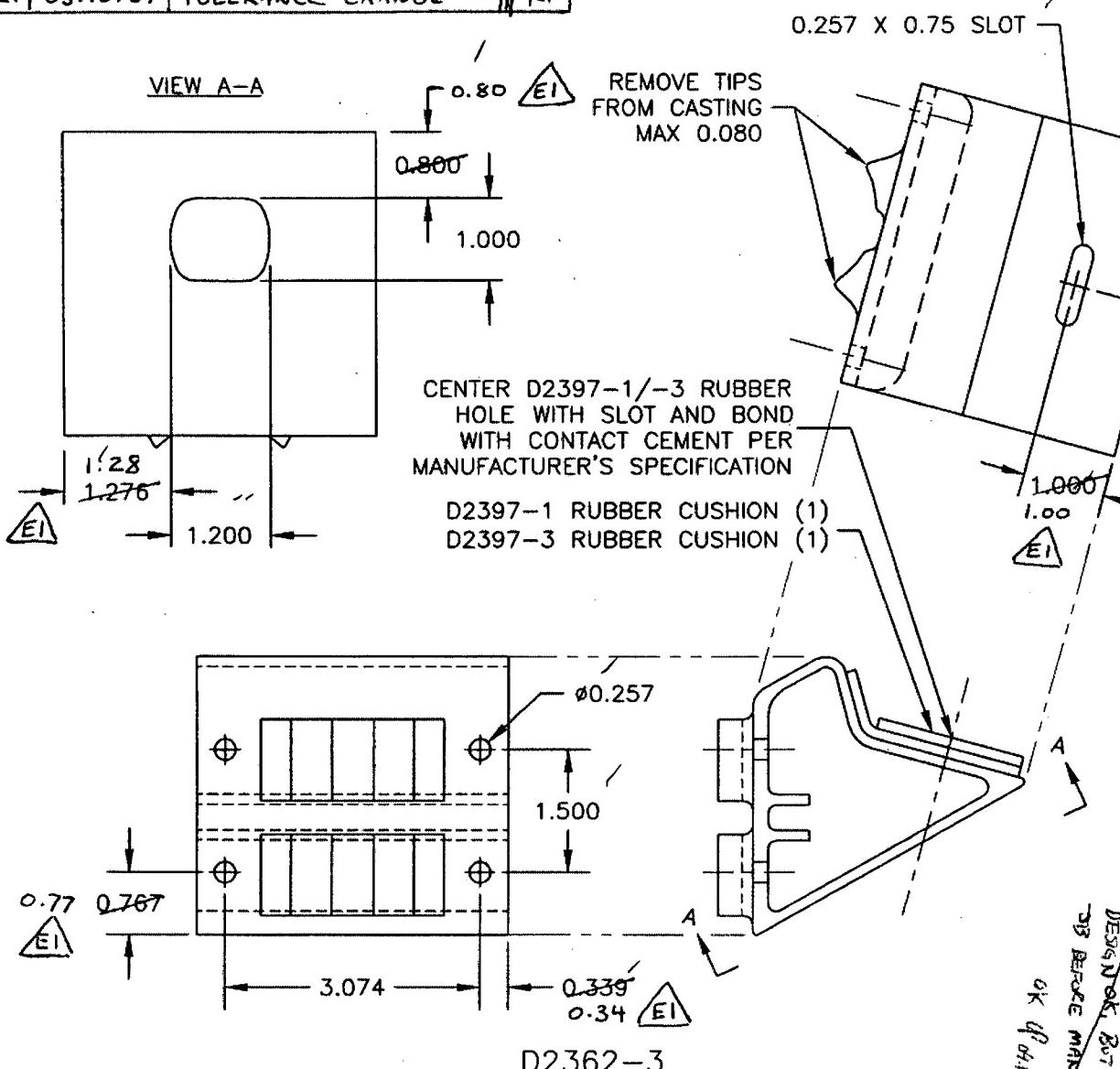
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>Y</u>	Audited by:		Prototype Approval:	N/A
Date:	09/07/11	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

EI 03.10.07 TOLERANCE CHANGE REF



RELEASED
98.12.14 KE

DART
Scanned by

DESIGN BW	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA REV. E
CHECKED KE	APPROVED JF	DRAWING NO. D2362 SHEET 1 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

12/1.03.15 GP
DESIGN OK, BUT CHECK WITH
TB BEFORE MANUFACTURE
OK if off by .05

NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

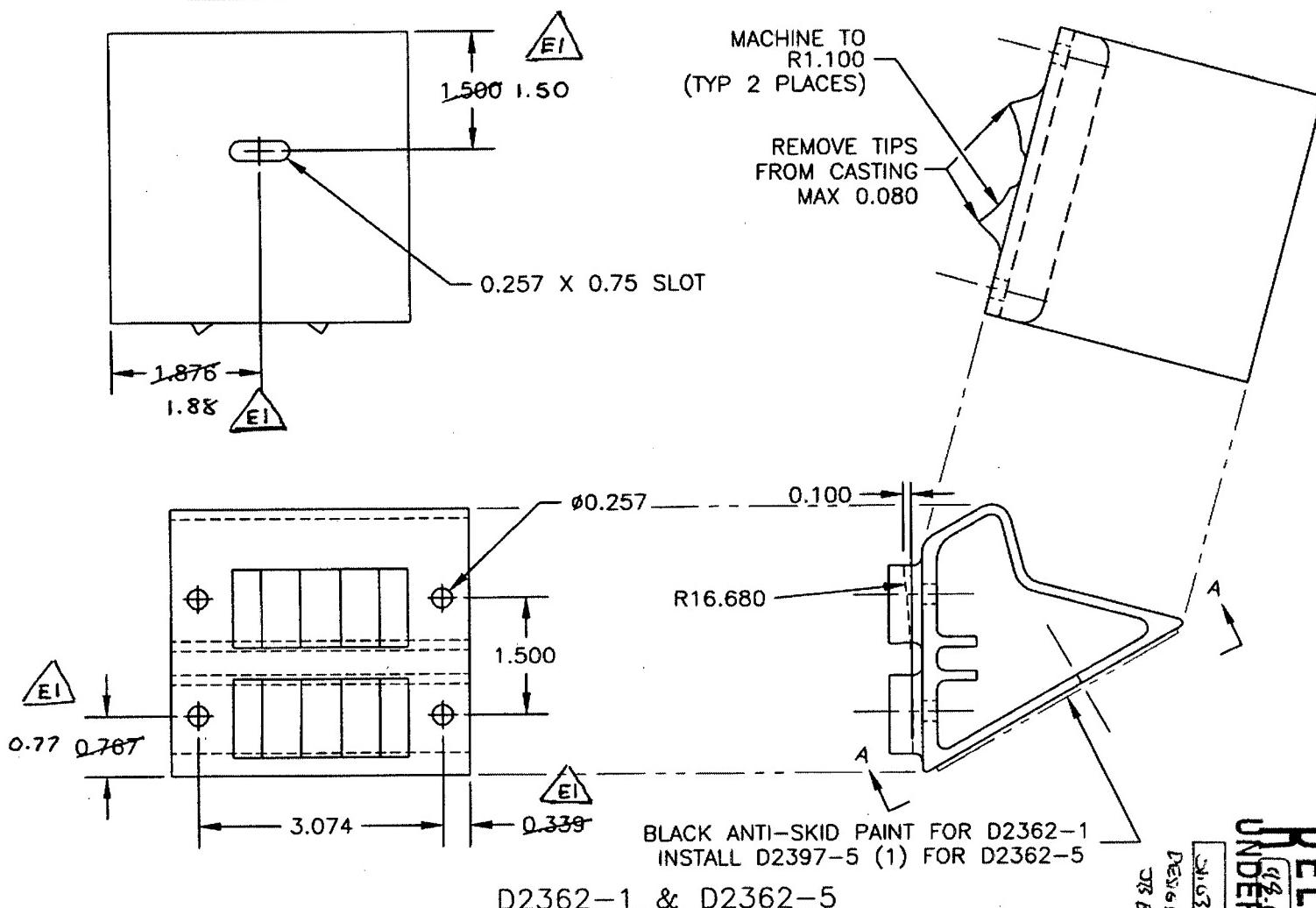
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

VIEW A-A



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

© COPY IS
DENIED

DESIGN BY	DRAWN BY	DART AEROSPACE LTD
BW	GP	HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KC	SH	D2362
DATE		STEP SUPPORT BRACKET
98.12.04		TITLE
		SHEET 2 OF 3
		SCALE 1:2

RELEASED
4-12-14
UNDER REVIEW
346385-4P
DESIGNOK, BUT CHECK W/
TR BEFORE MANUFACTURE
OK P
FEB 14 1999

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2362-041 (SHOWN)

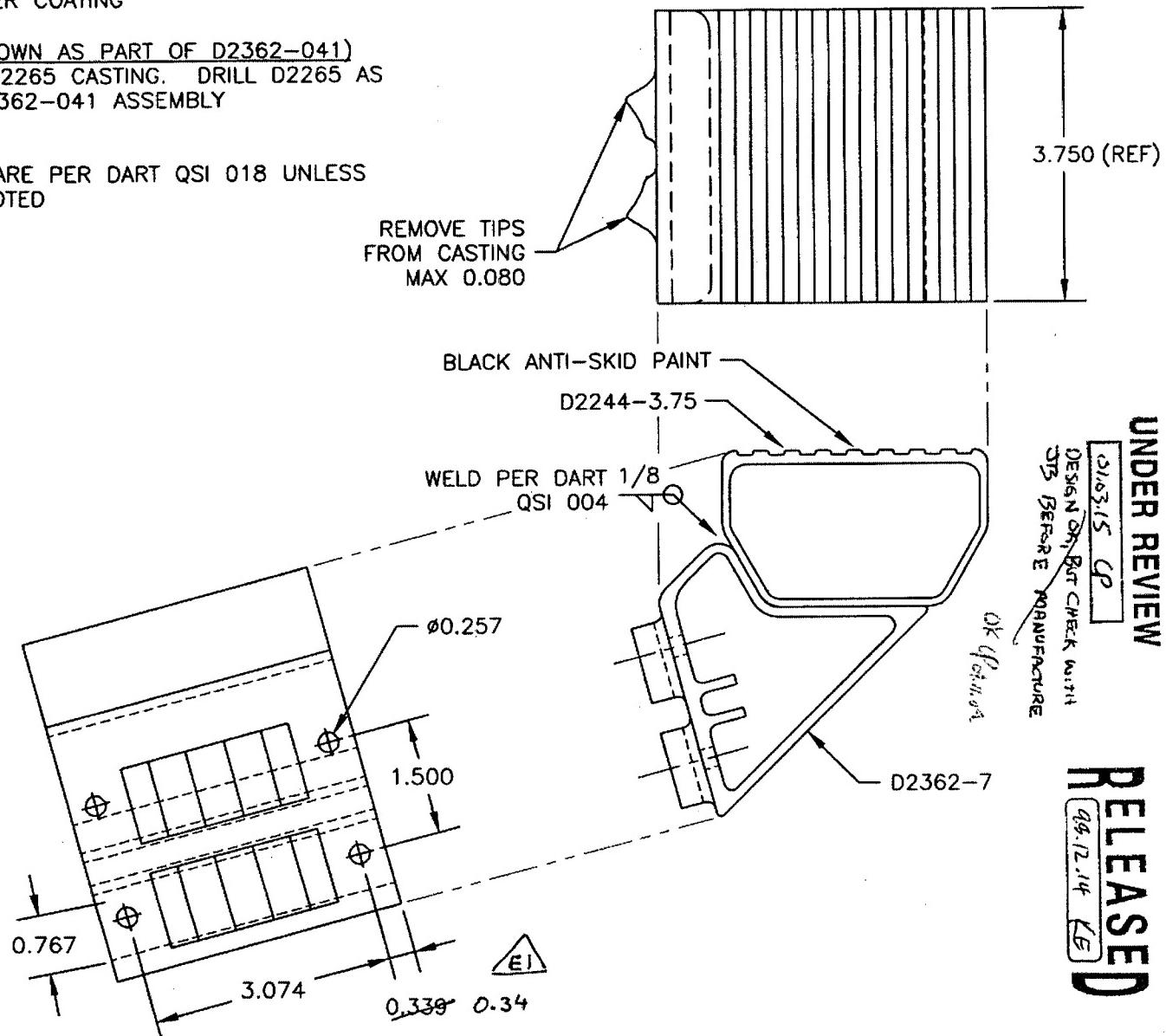
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DART

DA COPY
03/04/95

DESIGN BW	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED RE	APPROVED MM	DRAWING NO. D2362
DATE 98.12.04	STEP SUPPORT BRACKET	SHEET 3 OF 3 SCALE 1:2

UNDER REVIEW

RELEASED
44-12-14
LE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries